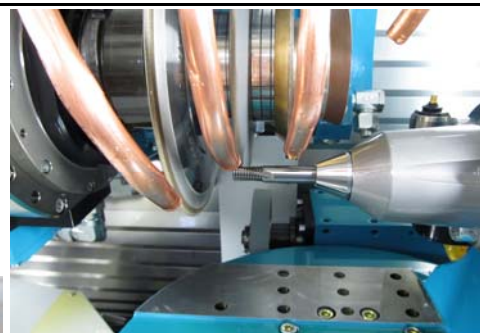
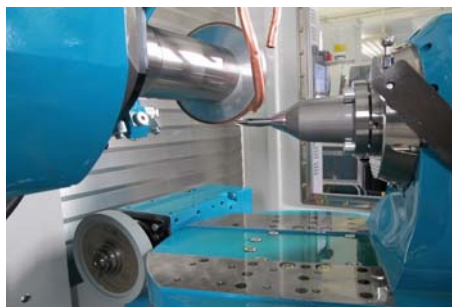


Thread Milling Cutter Ø9 Z3

A10-200

The production of thread milling cutters consists of gap operations with V-shaped wheels grinding the cam relief of the thread. A final tip operation flattens the treadtip to the nominal diameter. The below sample is a tapered thread millin cutter.



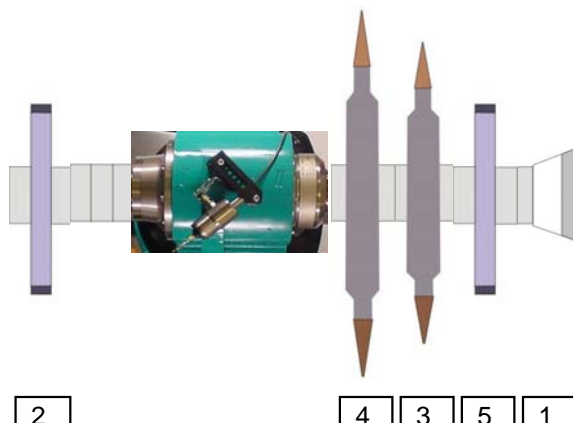
1. Cycletime for Production

Workpiece: Ø 9 mm, Z 3, Length 32 mm, Helix angle 15° Material CARBIDE									
Operations									
Feed [mm/Min]	2000	80	500	70	300	500	500	200	9000
Power [kW]		3	3	2	2	1	1	1	1
Cutting feed [m/s]		20	20	20	22	22	22	22	
Used wheels									
Grinding time [s]	12	22	74	103	106	63	63	103	19
Total cycle time	9 Min 25								

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	11V9 Ø75 D64
2	1A1 Ø125 D64
3	14EE1 Ø200 D76V60°
4	14EE1 Ø250 D46V60°
5	1A1 Ø125 D46



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Control: Fanuc 31i

Accessories:

Responsible engineer: OP. 2.5.11

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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